

Date: Wednesday, 6/27/2007 1:08:38 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARPAD	
Job Number	: 33227				
Estimate Number	: 12712				
P.O. Number	: N/A		Part Number	: D35371	
This Issue	6/27/2007	S.O. No. : N/A	Drawing Number	: D3537 REV C	
Prsht Rev.	: NC		Project Number	: N/A	
First Issue	: N/A		Drawing Revision	: C	
Previous Run	: 32539		Material	: N/A	
Written By			Due Date	: 7/10/2007	
Checked & Approved By			Qty:	40	Um: Each
Comment	: Est Rev: A New Issue 07-02-14 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 .063 Sheet
Comment: Qty.: 0.0788 sf(s)/Unit Total : 3.1500 sf(s) M304S16GA .063" 304 SS SHEET M19052 X 197 Batch: M7106 M103433 1B 07-07-06		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3537 Dwg Rev: C 1B 07-07-06 Prog Rev: C		
2-Deburr if necessary SAO 07/07/16		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE 1B 07-07-06		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK Ep 07/07/16		
5.0	BRAKE NC	NC BRAKE
Comment: NC BRAKE 1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326. 2-Identify as D3537-1 SAO 07/07/16 441		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/07/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/07/06	# 20	the .220" & 0.380" holes are under a .200" by .005"	<i>Initial</i>	Open holes manually using a fine tooth die grinder to bring them to within tolerance.	SAO 07/07/06	<i>Initial</i>	<i>Initial</i>	<i>Initial</i>
		R.C.						

NOTE: Date & initial all entries

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Job Number: 33227		Part Number: D35371
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
		
Comment: LARGE FABRICATION RESOURCE 1		
Qty	Description	Batch
A/R	2059B Hardcoat	<i>M10414963</i>
1-Weld as per Dwg D35371 using Jig DT 8210		
2-Remove any weld that penetrated through Wearpadif necessary		
7.0	QC9	VISUAL WELDING INSPECTION
		
Comment: VISUAL WELDING INSPECTION		
8.0	QC5	INSPECT WORK TO CURRENT STEP
		
Comment: INSPECT WORK TO CURRENT STEP		
9.0	POWDER COATING	POWDER COATING
		
Comment: POWDER COATING		
Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3		
10.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
		
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		
11.0	PACKAGING 1	PACKAGING RESOURCE #1
		
Comment: PACKAGING RESOURCE #1		
Identify and Stock Location: <i>FP-18</i>		
12.0	QC21	FINAL INSPECTION/W/O RELEASE
		
Comment: FINAL INSPECTION/W/O RELEASE		
Job Completion		
<i>7/27/07 26</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	33227
Description: Wearpad	Part Number:	D3537-1
Inspection Dwg: D3537 Rev: C		Page 1 of 1

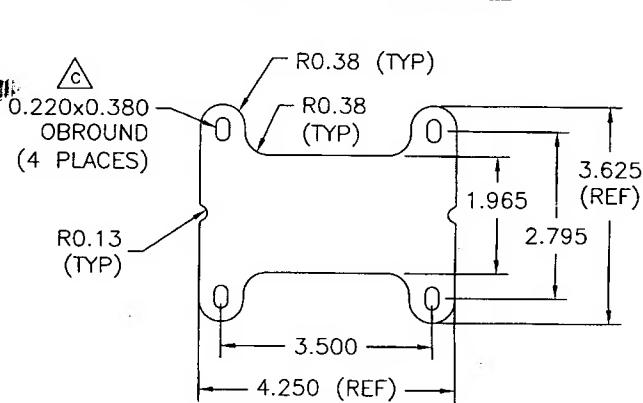
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

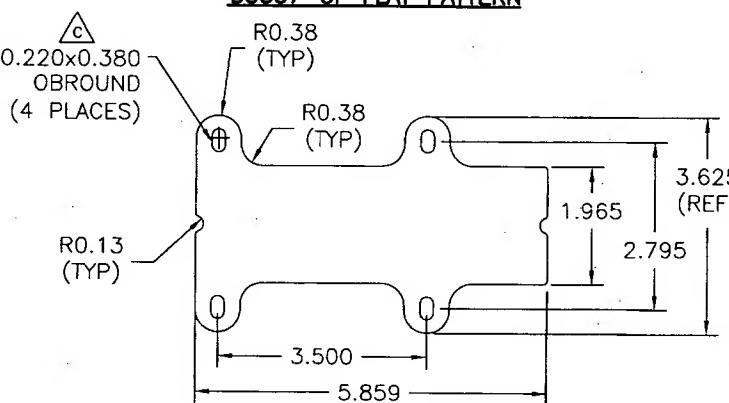
Measured by: <u>BS</u>	Audited by: <u>CR</u>	Prototype Approval: N/A
Date: 07-07-09	Date: 07/07/11	Date: N/A

Rev	Date	Change	Revised by	Approved
A	07.03.21	New Issue	KJ/JLM	
B	07.04.27	Dimensions revised per Dwg Rev. B	KJ/JLM	
C	07.05.28	Dimensions revised per Dwg Rev. C	KJ/JLM	

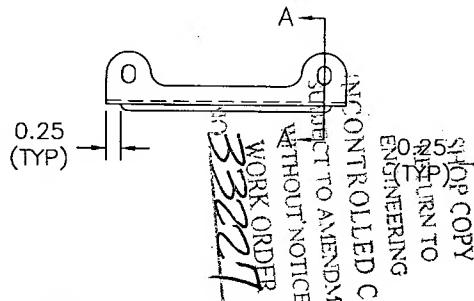
D3537-1F FLAT PATTERN



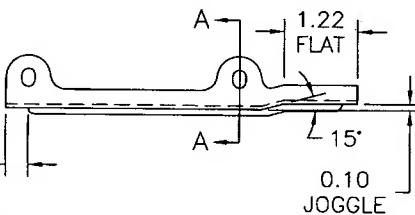
D3537-3F FLAT PATTERN



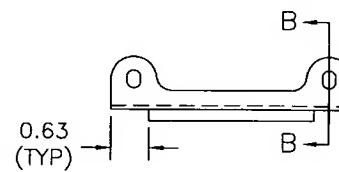
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



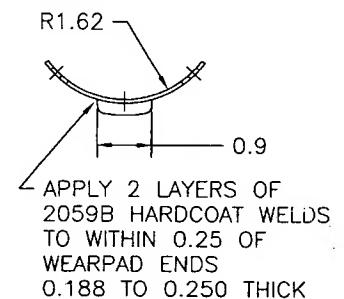
D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



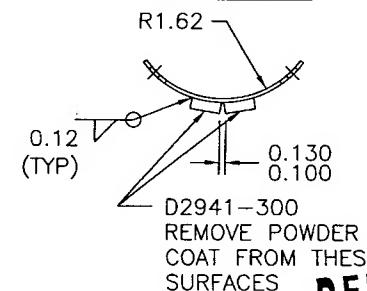
D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

SECTION A-A

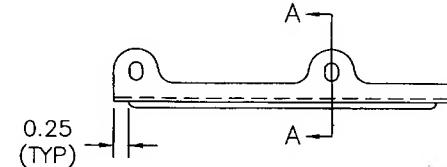


SECTION B-B



RELEASED
07.05.08 AM
PC ECLN
952

D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



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C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D3537
DATE		REV. C TITLE WEARPAD SCALE 1:2
07.04.13		